

TECHNICAL DATA SHEET

PRESTIGE CLEAR



PRODUCT FEATURES

- Easy 1 to 1 Mix
- Long Term Durability
- Compatible with any Basecoat
- Exceptional Flow and Leveling
- Can be applied **Wet On Wet** for increased productivity.
- Excellent Spot, Panel and Overall Clear
- High Gloss and D.O.I.
- Convenient Packaging

AVAILABILITY

Clear (Part A)		Unit	Per Case	Activator (Part B)		Unit	Per Case
ACL-1650-2	Prestige Clear	½GAL	6	BCL-1657-4	Fast Activator	QT	6
ACL-1650-4	Prestige Clear	QT	6	BCL-1658-4	Medium Activator	QT	6
				BCL-1659-4	Slow Activator	QT	6

PHYSICAL PROPERTIES

Color	Transparent	Weight Solids (RTS)	41.9 % to 42.5%
Pot Life	4 hours	Theoretical Coverage @ 1 mil (A+B)	576.7 sq ft
Flash Point	1°F	Gloss 20°/60°	80+ GU "Gloss Units" / 90+ GU "Gloss Units"
Dry Film Build	2.2 to 2.5 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity (RTS)	14" to 16" #2 Zahn Cup	Repairability Catalyzed	Excellent
EPA VOC (RTS)	≤4.7 (lb/gal)	Humidity Resistant	Excellent
ACTUAL VOC (RTS)	≤4.4 (lb/gal)		

ACRYLIC URETHANE CLEAR

DRY TIMES @ 70°F



Air Dry

Dust Free	15 minutes
Flash	Until Hand Slick (approximately 5-10 min).
Wet on Wet "Limited Flash"	2 to 5 minutes
Sand & Buff	14 to 16 hours

Force Dry

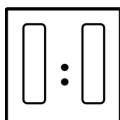
Bake @ 140°F for 30 minutes.

Note:

1. Only use slow activator when force drying.
2. Allow vehicle to cool down to room temperature before sanding and buffing.

Note: All tests are performed at 70°F, higher temperatures will provide faster buffing times.

MIX RATIO



1	Part Clear	PRESTIGE CLEAR
1	Part Activator	Activator (see availability table for options)

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 65°F will severely retard dry times and through cure.

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.4 mm	7 to 10 PSI
RP type	1.3 to 1.4 mm	7 to 10 PSI

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise 1 and 1/4 turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish. Improper adjustment may cause paint defects such as orange peel, runs and sags, and poor drying.

SURFACE PREPARATION

Follow all procedures from your basecoat manufacturer for surface preparation, dry and recoat times. DO NOT DEVIATE FROM THESE RECOMMENDATIONS.

GENERAL INFORMATION

- Always consider the following when choosing an activator: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.

PAINTING FLEXIBLE PARTS: A flexible additive may be needed when painting certain flexible parts. Follow manufacturers recommendations.

FISH EYE: The use of fish eye eliminator is strongly discouraged. If a fish eye additive is needed, use urethane fish eye eliminator, mix 1/2 ounce per sprayable quart. Use no more than necessary as it will directly affect flow out of EASY CLEAR.

APPLICATION

Apply 2 to 3 full wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 5 to 10 min) before applying the next coat. A Wet on Wet "Limited Flash" application can be used allowing 2-5 minutes flash between coats. Apply all coats within 1½ hours. If sanding and buffing, three coats of clear must be applied for long-term durability.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.